Work Order ID 67372

Thursday, March 17, 2011 7:24:26 AM

Item ID: D3339-3 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Wearpad Center

Start Date: 3/17/2011 **Start Qty:** 10.00 **Cust Item ID:**

Required Date: 3/22/2011 **Req'd Qty:** 10.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** ✓ **Date:** **Tooling:** **Date:**

QC: **Date:** **SPC (Y/N):** **Date:**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D3339	Rev *B								
100	FLOW WATER JET	0.00							
Waterjet	**Memo**	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3339 ☐Dwg Rev: B ☐Prog Rev: B ☐2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	**Memo**	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
QC	**Memo**	0.00							
Quality Control									

11 03 17 (10)

11 03 17 (10)

5 11/03/17

(10)

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
Brake NC	NC BRAKE					10			
Brake NC	**Memo**	0.00							
	1-Deburr if necessary□2-Form as per Dwg D3339 using DT8326 and DT8261								
	SB 11/03/18								
140	QC5- Inspect part completeness to step on W/O	0.00							
QC		5 11/03/18				10			
Quality Control	**Memo**	0.00							
150		0.00							
Large Fab	Large Fab								
Large Fab	**Memo**	0.00							
	1-Weld Hard coat 7560 per Dwg D3339,use DT8210 & DT8810 Layout Jig□A/R 7560 Hardcoat Batch: M116772								

EZ 11-3-21 x10

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Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC10- Inspect visual per QSI004- ground welds	0.00							
QC									
Quality Control	Memo	0.00							

S 11/03/22 X10

170	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
Powdercoat									
Powder Coating	Memo	0.00							

START TIME: 12:00 OVEN TEMPERATURE: 320 °F

FINISH TIME: 12:30

N 11/5/28

10X M-L 11/03/22

180	QC3- Inspect Part Finish	0.00							
QC									
Quality Control	Memo	0.00							

10 BL 11-3-22

Work Order ID 67372

Thursday, March 17, 2011 7:24:26 AM

Item ID: D3339-3 **Accept** **Setup Start** **Stop**

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Start Date: 3/17/2011 **Start Qty:** 10.00 **Cust Item ID:**

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Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: 497A	0.00							
Packaging	Memo	0.00							
Packaging								CY 11/3/22	(10)
200	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00						11/3/22	
Quality Control								CY 11/03/22	

Picklist Print

Thursday, March 17, 2011 7:24:24 AM

Work Order ID: 67372

Parent Item: D3339-3

Parent Item Name: Wearpad Center

Start Date: 3/17/2011 **Required Date:** 3/22/2011

Start Qty: 10.00 **Required Qty:** 10.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010S16GA 1010/1025 sheet 16GA		Purchased	No				sf	44.6250		1	11.03.17		

Location	Loc Qty	Loc Code
MAT	44.5	
116791	44.5	
MAT19	0.125	
111410	0.125	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\FORMS\Quality Assurance\approved QA\NCRWO RevE

DART AEROSPACE LTD	Work Order:	67372
Description: Wearpad	**Part Number:**	D3339-3
Inspection Dwg: D3339 **Rev:** B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.250 x 0.300	+0.005/-0.001	0.250 x 0.300	✓		Vern	MM-01
3.500	+/-0.010	3.502	✓		Vern	MM-01
0.250	+/-0.010	0.250	✓		Vern	MM-01
2.815	+/-0.010	2.808	✓		Vern	MM-01
1.815	+/-0.010	1.818	✓		Vern	MM-01
0.50	+/-0.010	0.502	✓		Vern	MM-01
4.00	+/-0.010	4.001	✓		Vern	MM-01
2.315	+/-0.010	2.317	✓		Vern	MM-01

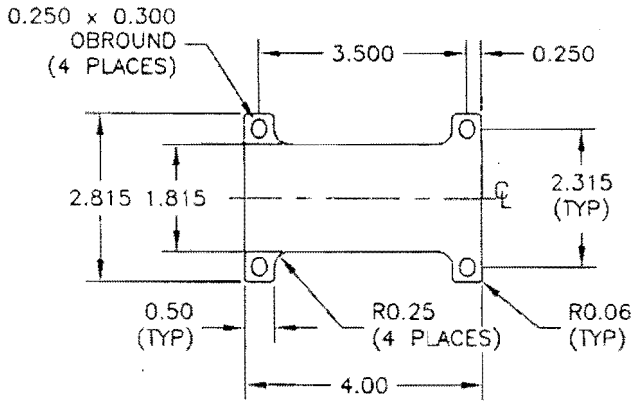
Measured by:	MM	Audited by:	S	Prototype Approval:	N/A
Date:	11.03.17	Date:	11/03/17	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.01.22	New Issue	KJ/EC/DD	

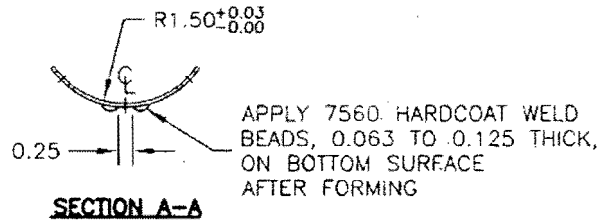
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
MB	MB		
CHECKED	APPROVED	DRAWING NO. D3339	REV. B SHEET 1 OF 3
DATE 05.11.22		TITLE REPLACEMENT WEARPAD	SCALE 1:3

A	05.06.06	NEW ISSUE
B	05.11.22	CORRECTED HOLE SPACING D3339-7F

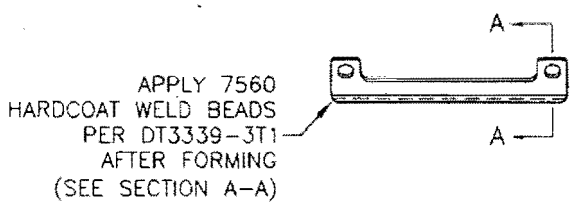
RELEASED 05-11-27



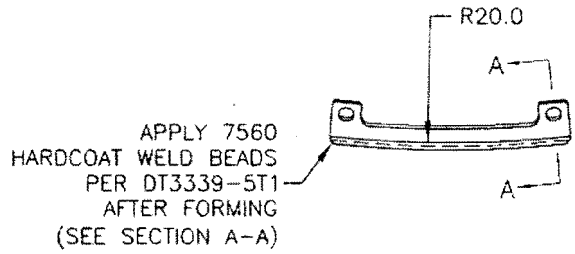
D3339-1F FLAT PATTERN



SECTION A-A



D3339-3 CENTER WEARPAD
(MADE FROM D3339-1F)



D3339-5 FORWARD WEARPAD
(MADE FROM D3339-1F)

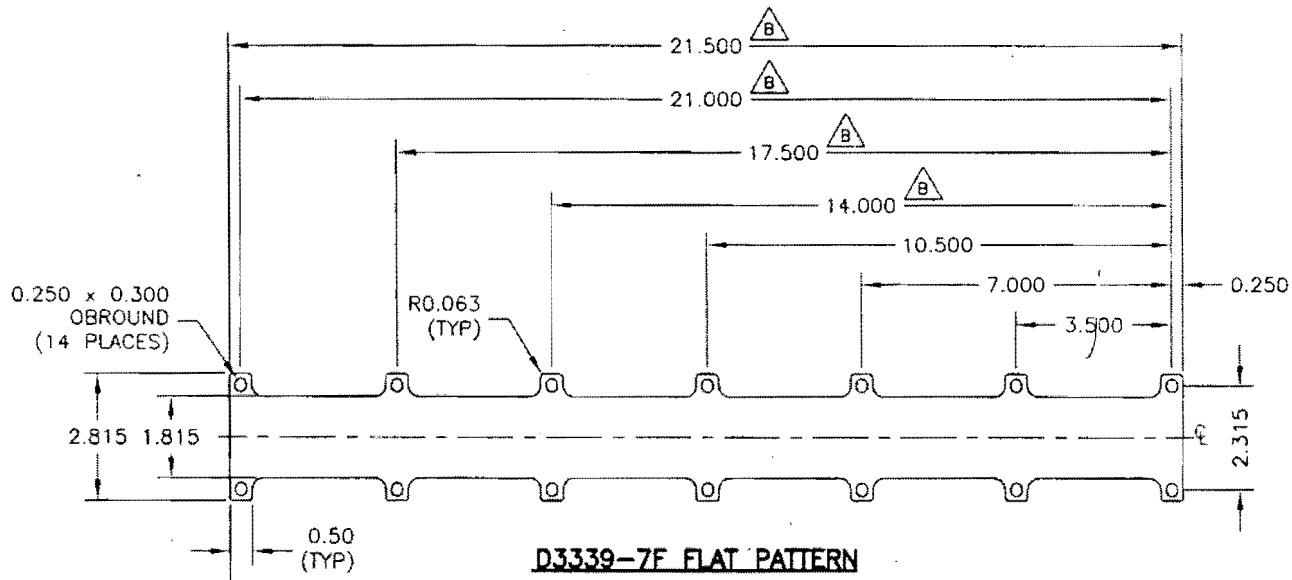
D3339-1F/-3/-5 WEARPAD

NOTES:
1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES COLD ROLLED STEEL 16 GAUGE (0.060 THICK)
2) PART IS SYMETRICAL ABOUT CENTER LINE
3) WELD PER DART QSI 004
4) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
6) ALL DIMENSIONS ARE IN INCHES
7) BREAK ALL SHARP CORNERS 0.063 MAX

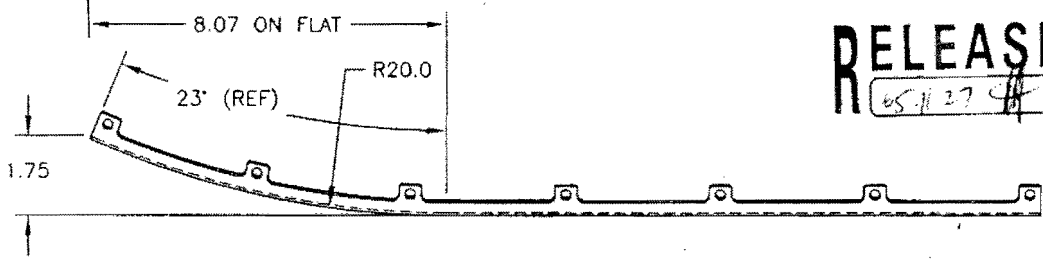
N667372

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
MB	MB		
CHECKED	APPROVED	DRAWING NO.	REV. B
		D3339	SHEET 2 OF 3
DATE		TITLE	SCALE
05.11.22		REPLACEMENT WEARPAD	1:4

DART

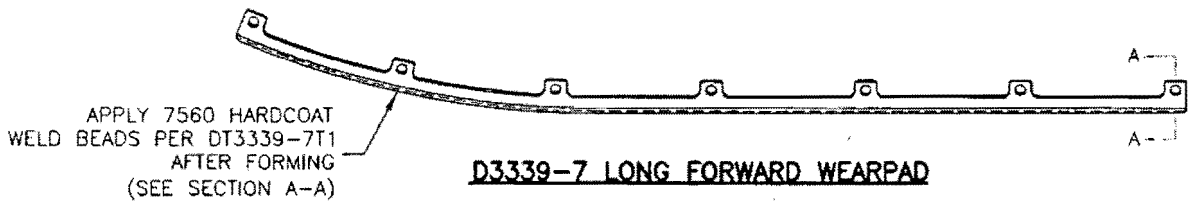


D3339-7F FLAT PATTERN



RELEASED 05.11.27

D3339-7B LONGITUDINAL BEND



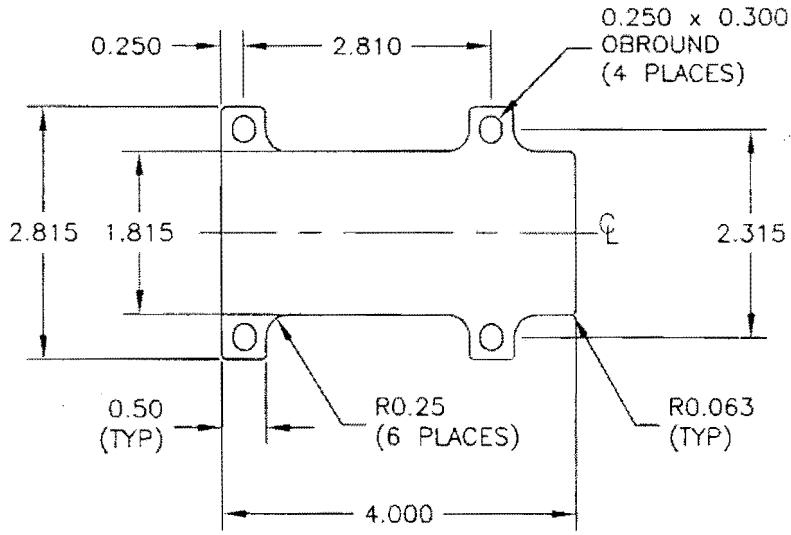
D3339-7 LONG FORWARD WEARPAD

67372

NOTES:

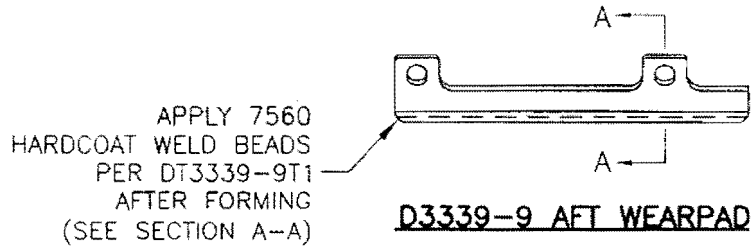
1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES COLD ROLLED STEEL 16 GAUGE (0.060 THICK)
2) PART IS SYMETRICAL ABOUT CENTER LINE
3) WELD PER DART QSI 004
4) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
6) ALL DIMENSIONS ARE IN INCHES
7) BREAK ALL SHARP CORNERS 0.063 MAX

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
MB	MB		
CHECKED	APPROVED	DRAWING NO.	REV. B
		D3339	SHEET 3 OF 3
DATE		TITLE	SCALE
05.11.22		REPLACEMENT WEARPAD	1:2



D3339-9F FLAT PATTERN

RELEASED
05.11.27



D3339-9 AFT WEARPAD

67372

NOTES:

1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES COLD ROLLED STEEL 16 GAUGE (0.060 THICK)
2) PART IS SYMETRICAL ABOUT CENTER LINE
3) WELD PER DART QSI 004
4) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
6) ALL DIMENSIONS ARE IN INCHES
7) BREAK ALL SHARP CORNERS 0.063 MAX